



**Work Order ID 51924**

Wednesday, September 09, 2009 11:35:42 A



Page 2

Item ID: D2571

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 9/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

*MWT  
09/10/21*
*6*
*X*

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

*BK09-10-21*
*⑥*

0.00

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

*M1112260  
=7 09/10/22*
*(XG)*
*X*

 Memo  
 START TIME: 8:00AM OVEN TEMPERATURE:  
8:30AM FINISH TIME: 320°F

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Start Date: 9/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

*BL 0910-22*

0.00



QC

Memo

Quality Control

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

Packaging

*9/10/23 6x80*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

*A 09.10.27*

*WF 09-10-24*

# Picklist Print

Page 1

Wednesday, September 09, 2009 11:35:51 AM

Work Order ID: 51924



Parent Item: D2571RevE



Parent Item Name: Saddle, Fwd Out 205

Start Date: 9/11/2009

Required Date: 9/18/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007RevB		Manufactured		No		100	Each	0.0000	6.0000			

Saddle Billet

Batch # B46412 and 09/10/20 6

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

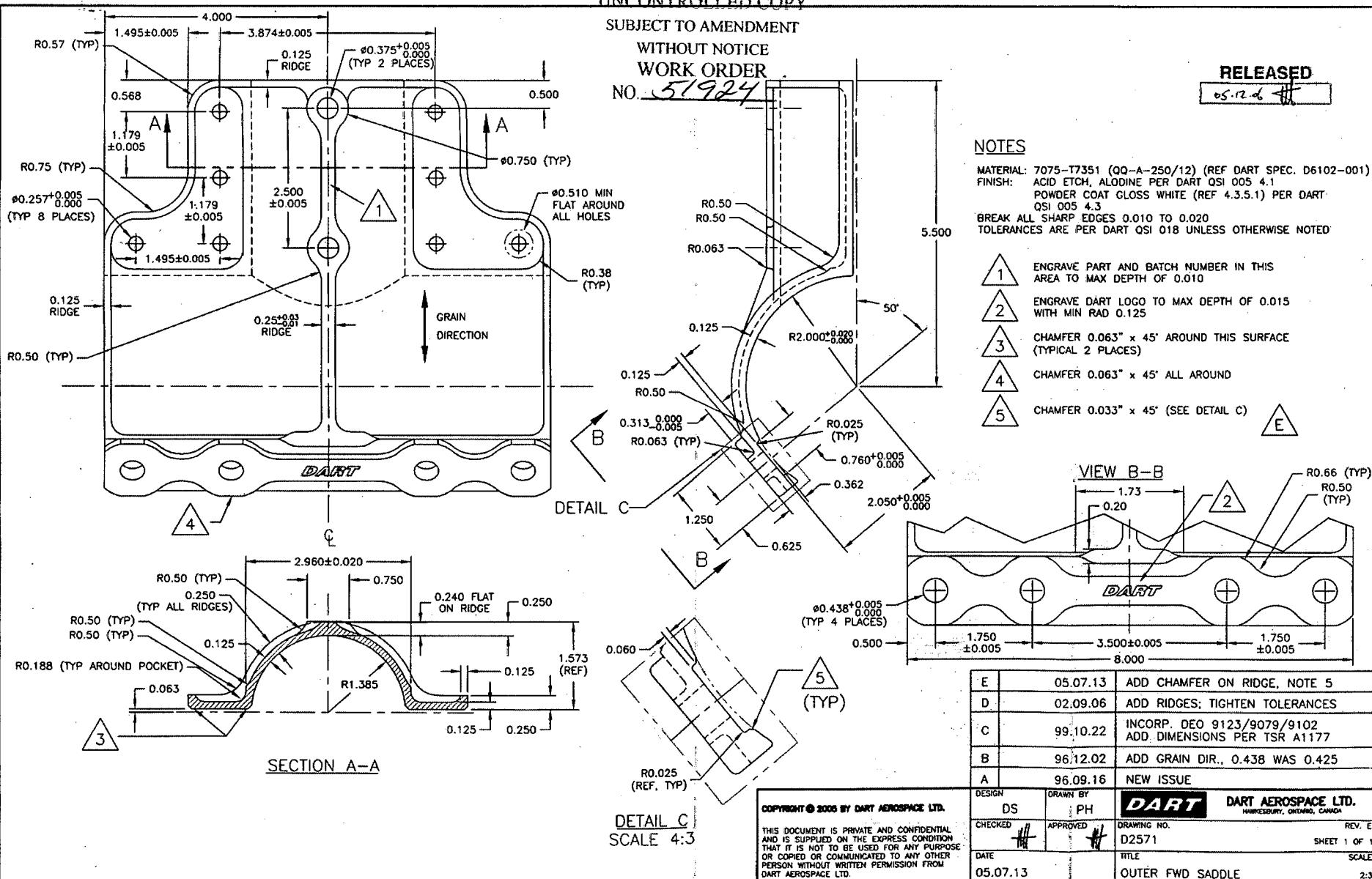
WITHOUT NOTICE

WORK ORDER

NO. 57924

RELEASED

05.12.06



DART AEROSPACE LTD	Work Order:	51924
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.439	.439		
B	1.745	1.755		1.750	1.749	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.499	3.499		
D	1.745	1.755		1.750	1.749	1.749	1.749		
E	7.990	8.010		8.000	8.002	8.003	8.001		
F	0.490	0.510		.501	.503	.504	.505		
G	0.257	0.262		.258	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.498	.497	.498	.497		
J	1.174	1.184		1.179	1.180	1.180	1.180		
K	0.558	0.578		.564	.565	.566	.565		
L	1.174	1.184		1.179	1.180	1.180	1.180		
M	1.490	1.500		1.496	1.496	1.496	1.496		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.875		
P	0.115	0.135		.123	.125	.121	.122		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.246	.251	.252	.249		
S	0.115	0.135		.125	.124	.130	.130		
T	0.178	0.198		.188	.188	.189	.189		
U	2.940	2.980		2.960	2.962	2.960	2.962		
V	0.230	0.250		.235	.243	.240	.239		
W	0.115	0.135		.124	.127	.126	.128		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.356	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.633	.635	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.387	1.387	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.124		
AG	0.240	0.280		.255	.260	.260	.260		
AH	0.240	0.260		.246	.251	.252	.249		
AI	2.000	2.020		2.002	2.002	2.002	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	SP / GMF	Audited by:
Date:	09/10/18 / 09/10/20	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SP / GMF

DART AEROSPACE LTD	Work Order:	51924
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	54	-26	3	4	By	Date
A	0.438	0.443		.439	.439				
B	1.745	1.755		1.749	1.749				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.749	1.749				
E	7.990	8.010		8.002	8.002				
F	0.490	0.510		.504	.503				
G	0.257	0.262		.259	.259				
H	0.375	0.380		.377	.378				
I	0.490	0.510		.502	.501				
J	1.174	1.184		1.180	1.178				
K	0.558	0.578		.569	.568				
L	1.174	1.184		1.182	1.177				
M	1.490	1.500		1.496	1.494				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.123	.121				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.251	.248				
S	0.115	0.135		.133	.129				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.962	2.960				
V	0.230	0.250		.239	.240				
W	0.115	0.135		.118	.118				
X	0.308	0.313		.312	.312				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.365	.364				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.635	.635				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.249				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.255				
AH	0.240	0.260		.249	.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				

Accept/Reject

Measured by:	<i>SP</i>	/	<i>only</i>	Audited by:	
Date:	<i>09/10/19</i>	/	<i>09/16/21</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>